



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3812
Job Sheet 184738



Part No: 646.3812

Job Qty: 14 ea

Part Name: Gusset Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3800 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD IPP REV:B 18.07.03 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	14 Ea		10/31/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	14 pcs		10/31/18	0.00	3.25	Bandsaw1		18/10/15
110	Mill Conv	14 pcs		10/31/18	0.00	6.57	Mill Conv 1		18/10/16
120	QC	14 pcs		10/31/18	0.00	0.00	QC2 Machining-1		
130	QC	14 pcs		10/31/18	0.00	0.00	QC8 Machining-1		
140	Outsource	14 pcs		10/31/18			ATG001-VC	8	
150	Packaging	14 pcs		10/31/18	0.00	0.00	Packaging2		NOV 05 2018
155	QC	14 pcs		10/31/18	0.00	0.00	QC5		NOV 05 2018
180	Packaging	14 pcs		10/31/18	0.00	0.00	Packaging3-1		NOV 06 2018
190	QC21-SA	14 Ea		10/31/18	0.00	0.00	QC21		NOV 06 2018

Part Op 110 - 1-Machine per DWG

Descriptions: 140 - Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW
MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY
PRIMER (LIGHT GRAY) Certification of Conformity is required

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6A0.75X0.75X0.060X0.062	7075T6 Angle .75" X .75" X .060" X .062"W	1.4000 ft (.1 ea)	90-Start up Operation	FM136405

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6A0.75X0.75X0.060X0.062	1	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset Bracket	2.000Inches ± 0.010	2.010 1.990		
2	Gusset Bracket	0.060Inches ± 0.010	0.070 0.050		
3	Gusset Bracket	0.750Inches ± 0.010	0.760		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

			0.740
4	Gusset Bracket	0.060Inches $\pm$ 0.010	0.070 0.050
5	Gusset Bracket	0.310Inches $\pm$ 0.010	0.320 0.300
6	Gusset Bracket	0.060Inches $\pm$ 0.010	0.070 0.050
7	Gusset Bracket	0.380Inches $\pm$ 0.010	0.390 0.370
8	Gusset Bracket	1.250Inches $\pm$ 0.010	1.260 1.240
9	Gusset Bracket	0.090Inches $\pm$ 0.010	0.100 0.080

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

DART AEROSPACE
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 513 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S118939
Part: 646.3812
Job No: 184738
Serial No/Batch: S118939

Revision: A
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Date: 10/6/18

Root Cause

Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Inspection incomplete/Unqualified	☐	Wrong Stock Picked	☐	Part Lost/Missing	☐
Design	☐	Operator	☐	Bending	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	Countersink	☐	Off-set	☐	Drawing	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐						
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐						
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐						
Substation	☐	Process Improvement	☐	Marks/Chatter	☐						
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :	☐						



Dart Aerospace Ltd.
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PURCHASE ORDER

PO041414

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041414
PO Date: 10/22/18
Due Date: 11/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Belanger, NatashaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	184106	RBD29904	Hoist Adapter "D" Model -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625 TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$8.40/pcs	\$8.40
8	182772	D5573-1	Base Bracket, Upper, Cable Cutter, LH : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 2 CLASS 2 PRIME AS PER IAW MIL-PRF-23377 1-2 MIL MAX AS PER DWG NOTE 2 C OF C IS REQUIRED	Firmed	-	11/16/18	4 pcs	0 pcs	4 pcs	\$9.40/pcs	\$37.60



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PURCHASE ORDER **PO041414**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	182773	D5573-2	Base Bracket, Upper, Cable Cutter, RH : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 2 CLASS 2 PRIME AS PER IAW MIL- PRF-23377 1-2 MIL MAX AS PER DWG NOTE 2 C OF C IS REQUIRED	Firmed	-	11/16/18	4 pcs	0 pcs	4 pcs	\$9.40/pcs	\$37.60
11	184738	646.3812	Gusset Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760- 4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	11/16/18	14 pcs	0 pcs	14 pcs	\$6.70/pcs	\$93.80
12	183905	D5553-1	Bracket : Various STC's ISSUE P/O: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 C OF C IS REQUIRED	Firmed	-	11/16/18	10 pcs	0 pcs	10 pcs	\$5.80/pcs	\$58.00
Grand Total:											\$235.40

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9-89



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Canada

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PURCHASE ORDER PO041414

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/18 6:32 AM dart.belanger.natasha



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916411

Date: 02-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship to

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 14 ea	Part: 646.3812 ✓ Gusset Bracket - Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23965 PO: PO041414 ✓ Line: 11	Rev: N/C	DAS 68 9-89
✓ 10 ea	Part: D5553-1 ✓ Bracket Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils). Job: 23966 PO: PO041414 ✓ Line: 12	Rev: A	
✓ 4 ea	Part: D5573-1 ✓ Base Bracket, Upper Cable LH Hard Black Anodize per MIL-A-8625F, Type II, Class 2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Job: 23962 PO: PO041414 ✓ Line: 8	Rev: A	
✓ 4 ea	Part: D5573-2 ✓ Base Bracket, Upper Cutter RH Hard Black Anodize per MIL-A-8625F, Type II, Class 2, . Prime IAW Mil-P-23377 J Type I Class N; 1-2 mil max as per QSI 005 Job: 23963 PO: PO041414 ✓ Line: 9	Rev: A	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>2/4/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ Made in Canada.			

